Dart Aerospace Ltd.

Date: Monday, 1/14/2008 2:37:00 PM
User: Kim Johnston

Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 36747 -2		
Estimate Number	: 10255		
P.O. Number	:	Part Number	: D22301
This Issue	: 1/14/2008 S.O. No. :	Drawing Number	: D2230 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: F
Previous Run	: 36102	Material	:
Written By	:	Due Date	: 2/15/2008 Qty: 200 Um: Each
Checked & Approved By	: 08 01 15		
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
10	D2423	Lug Extrusion

Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)
Lug Extrusion D2423 Extrusion
Batch: 133310 CL08101115

20	BAND SAW	BAND SAW

cut at Metec

Comment: BAND SAW
Cut D2423 extrusion to 0.82"
Batch:_____

30	HAAS1	HAAS CNC VERTICAL MACHINING #1

PG Issue PO 5448 CL08101115 (20)

Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine per folio D2230-1
(Check for crack while loading into the machine.)
2-Tumble and deburr rough edges after tumbling

Machine per ~~folio~~ drwg D2230 Rev F

40	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

RG Receive + Inspect for transit damage

Comment: INSPECT PARTS AS THEY COME OFF MACHINE ensure C of C attached 8/2/5 (60)

50	QC5	SECOND CHECK

Comment: ~~SECOND CHECK~~ Inspect level 5 08/01/06 (+60) counts

Form: process

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 36747

Part Number: D22301

Job Number:

Seq. #:	Machine Or Operation:	Description :	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	60X
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		M. 08/02/07	
7.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP		08/02/07 x60	
8.0	POWDER COATING	POWDER COATING	
Comment: POWDER COATING Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3		m106379 FL 08/02/07	60
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	60
Comment: INSPECT POWDER COAT		AS · M. 08/02/08	
10.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: AS St 476		AS 08/02/01	x60
11.0	QC21	FINAL INSPECTION/W/O RELEASE	
Comment: FINAL INSPECTION/W/O RELEASE		08 02 13	

Job Completion

2008/2/11 60

DART AEROSPACE LTD	Work Order:	36747
Description: Mounting Lug	Part Number:	D2230-1
Inspection Dwg: D2230 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010					
0.306	+/-0.010					
0.345	+/-0.010					
0.400	+/-0.010					
0.250	+/-0.010					
3.700	+/-0.010					
0.750	+/-0.010					
Ø0.257	+0.005/-0.000					
1.91	+/-0.010					
R1.200	+/-0.010					
0.375	+/-0.010					
			N/A			
			00/02/06			

Measured by:	
Date:	

Audited by:	
Date:	

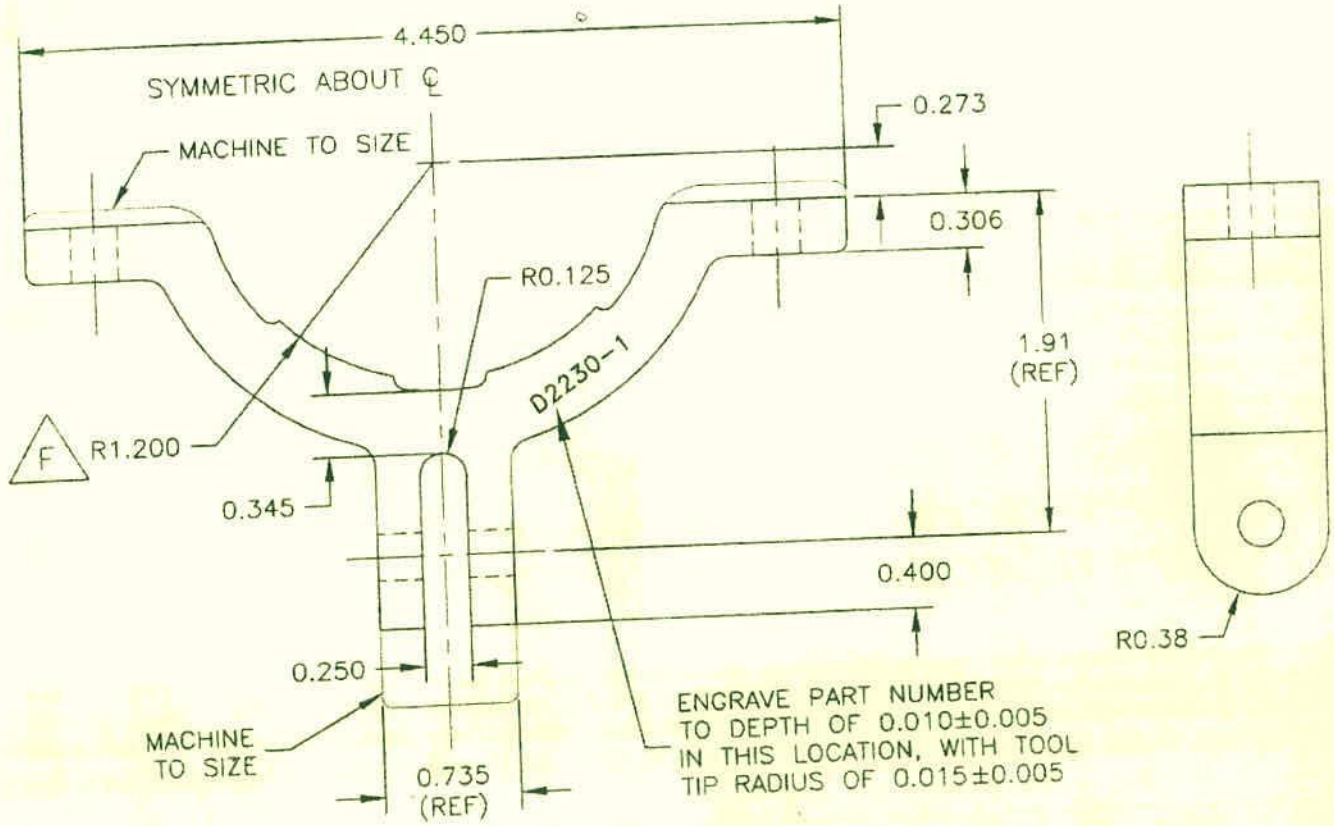
Prototype Approval:	N/A
Date:	

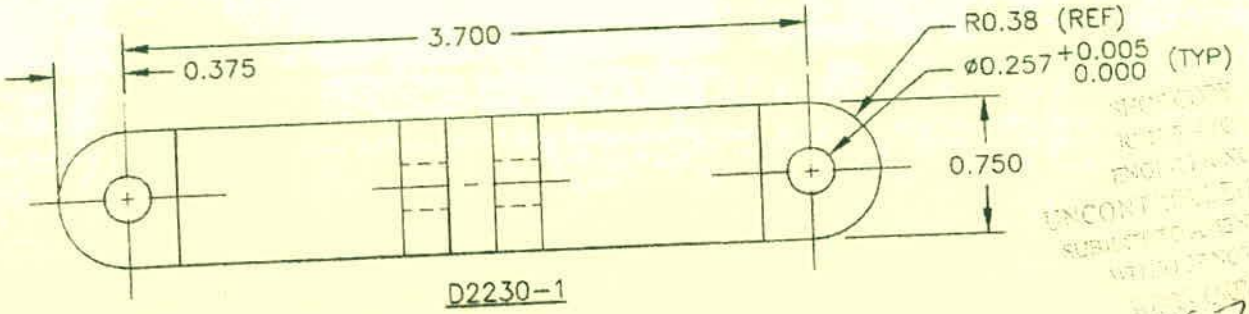
Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	RF

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED
99.12.21 DS





D2230-1

NO. 36747

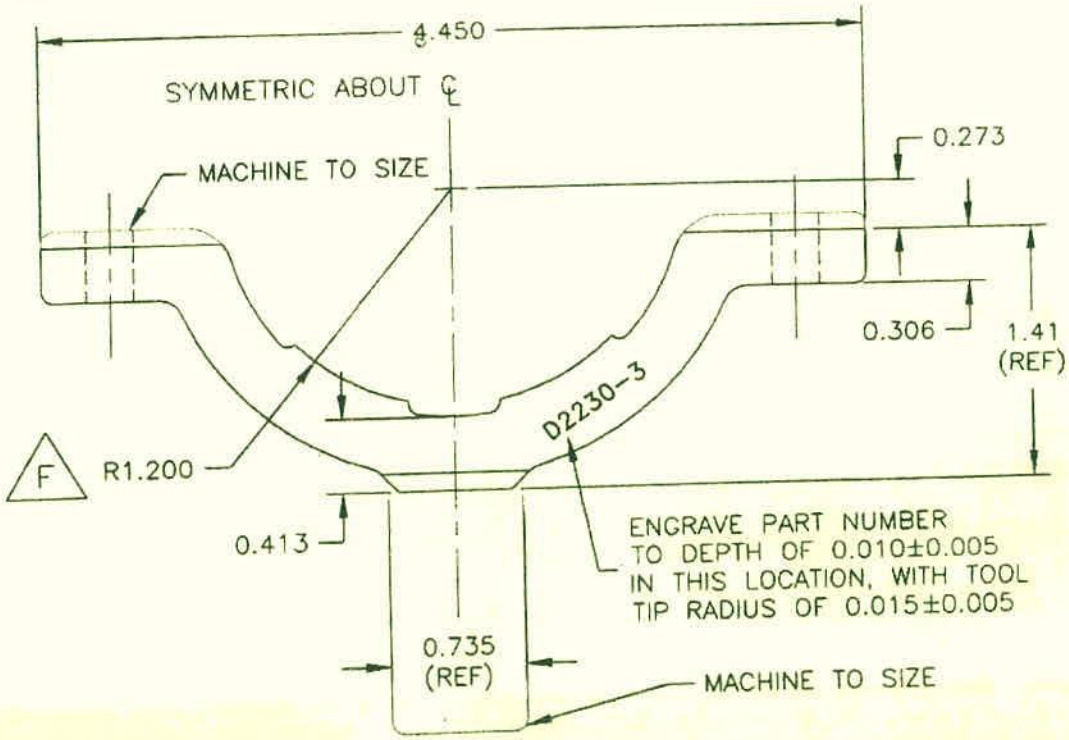
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

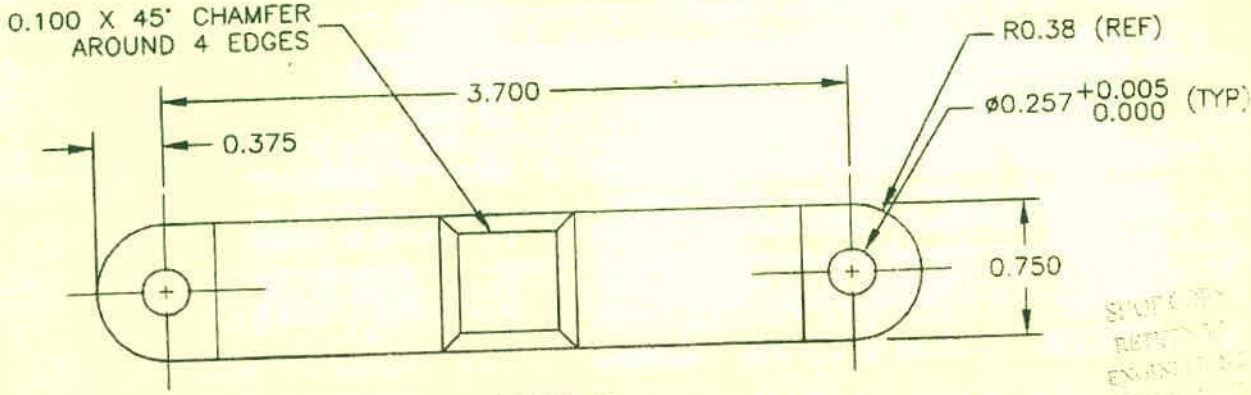
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2230	REV SHEET 2 OF
DATE 99.12.13		TITLE MOUNTING LUG	SC

DART

COPY ISSUED

RELEASED
99.12.21 DS





D2230-3

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 3674

METEC METAL TECHNOLOGY INC.

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
60	D2230-1	Lug B36747	P5448

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, February 5, 2008

20 Terry Fox Drive P.O. Box 781 • Vankleek Hill ON K0B 1R0 • (613) 678-3957 Fax: (613) 678-3956